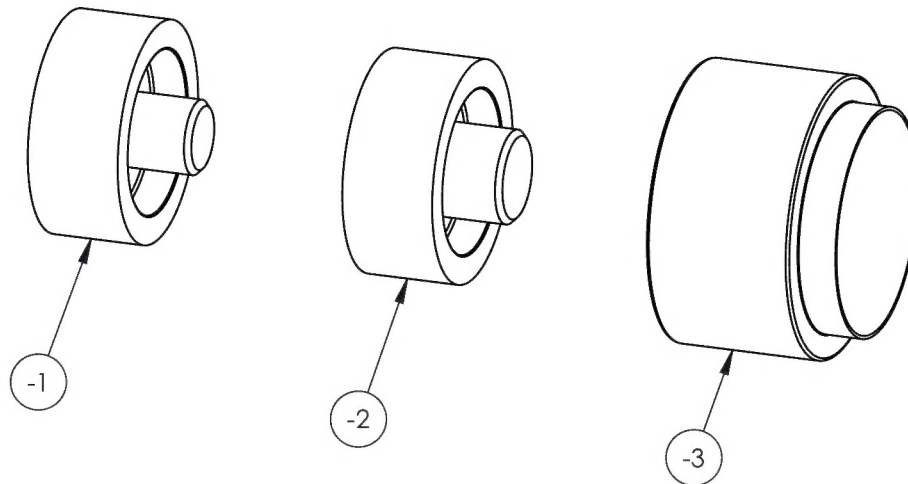


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		PARTS COUNT REDUCED: -6 ELIMINATED, -4 ID REDUCED TO Ø.995, -4 QTY INCREASED TO TWO, -5 STEP OD REDUCED TO Ø.995.	6/10/2004		
2		ADDED -3 AND -4 ROUGHING DETAILS, CHANGED -4 QTY TO 1.	7/7/2006		
3		-4 ADDED CHAMFER 45° AND LIMITS, CH'D DIM .996 TO .998 & P.F. -7, COMBINED PG'S 2 & 3, 4 & 5, 6 & 7, 8 & 9.	4/27/2009	RJC	
4		CH'D -5 FINISH DETAIL FROM Ø.995 +.001 -.000 TO Ø1.000 +.001 -.000, CH'D -7 FINISH DETAIL FROM Ø.998 +.001 -.000 TO Ø.999 +.001 -.000 & ADDED MISSING Ø1.000 +.001 -.000 P.F. -4 PER G.E. ADDED -9 PER RW.	10/24/2011	RJC	RW
5	15-0133	UPDATED TO NEW DRAFTING STANDARDS. -1 & -2 ADDED ASSY. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	6/8/2015	DPD	JAG
6	17-0047	UPDATED TO NEW DRAFTING STANDARD. -1, -2 ADDED FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D, -3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D, -4 CH'D FINISH WAS BLACK OXIDE IS SEE -1 & -2, -5 C'D DIM WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM 1.50, CH'D FINISH WAS BLACK OXIDE IS SEE -1, -7 CH'D DIM'S WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM'S .250, 1.50. CH'D FINISH WAS BLACK OXIDE IS SEE -2.	2/28/2017	RJC	JAG



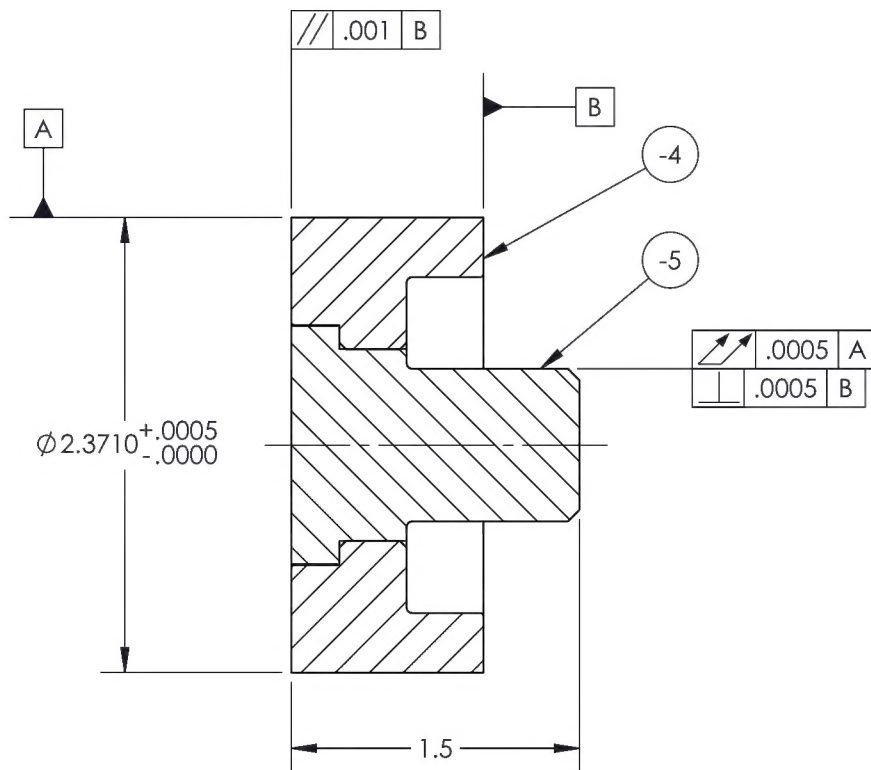
NOTE:  
SIMILAR TO 269T9320.

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL T/R PITCH CONTROL</b>	
DWG NO. <b>RB0006-809-00088</b>	REV <b>6</b>
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL <b>MD 500</b>	
SCALE <b>1:2</b>	DATE <b>12/10/2004</b>
SHEET 1 OF 7	

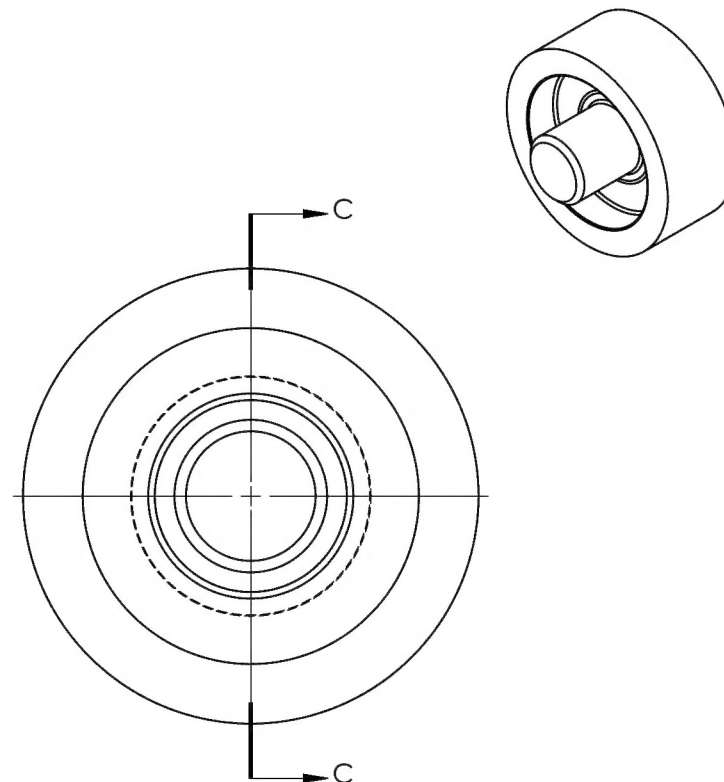
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	GUIDE ASSEMBLY			2
X			-2	1	GUIDE ASSEMBLY			3
			-3	1	PUNCH	O-1		4
1	1		-4		PILOT	O-1		5
	1		-5		GUIDE	O-1		6
1			-7		GUIDE	O-1		7
		B/O	-9	1	PISTOL CASE	PLASTIC	SMALL (RSR GROUP #10137)	N/S
ASSY -2	ASSY -1							

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0133	-1 ADDED ASSY.	6/8/2015	DPD	JAG
6	17-0047	-1 ADDED FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D.	2/28/2017	RJC	JAG



SECTION C-C

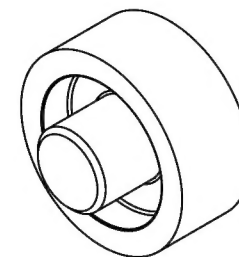
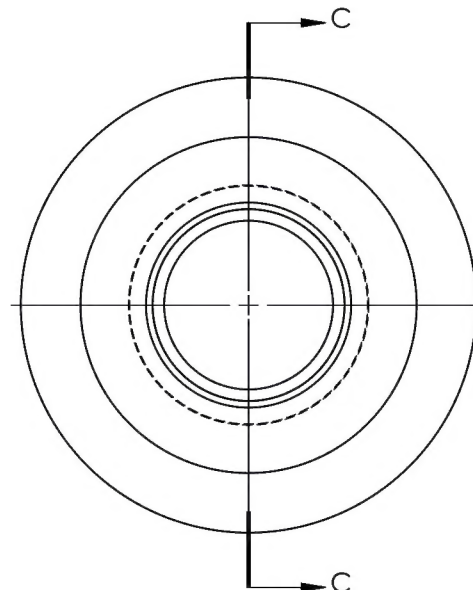
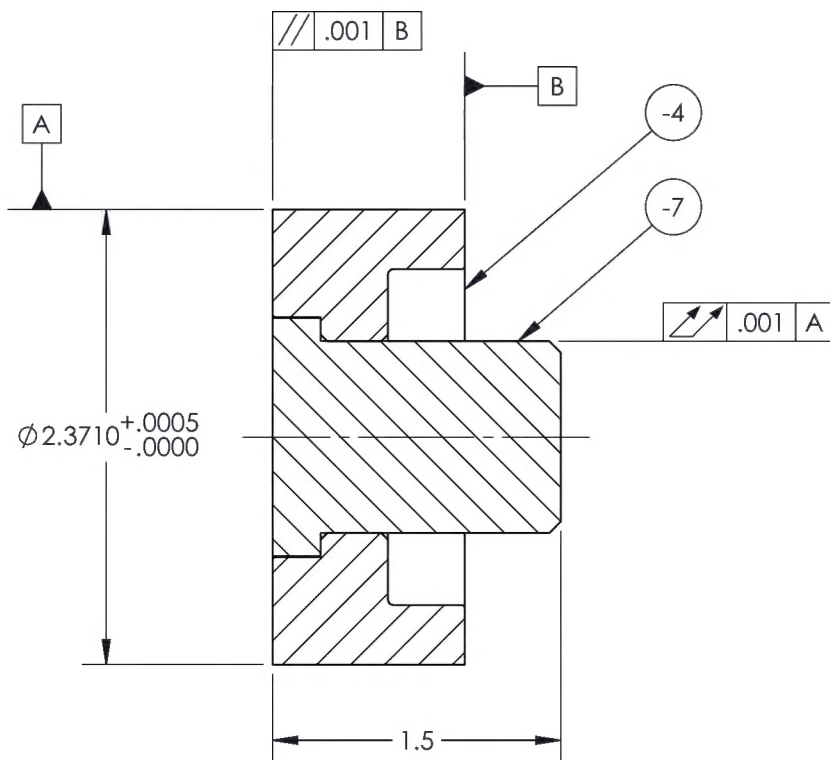


(-1)  
GUIDE ASSEMBLY

<b>DART</b> AEROSPACE	
TITLE STAKING TOOL T/R PITCH CONTROL	
DWG NO. RB0006-809-00088-1	REV 6
MAT'L REPT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	MD 500
APPROVED: GILBERT	
SCALE 1:1	DATE 12/10/2004
SHEET 2 OF 7	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
5	15-0133	-2 ADDED ASSY.	6/8/2015	DPD	JAG
6	17-0047	-2 ADDED FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D.	2/28/2017	RJC	JAG



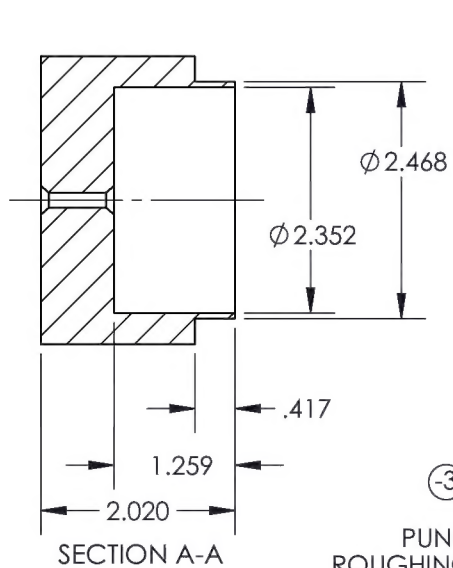
SECTION C-C

(-2)  
GUIDE ASSEMBLY

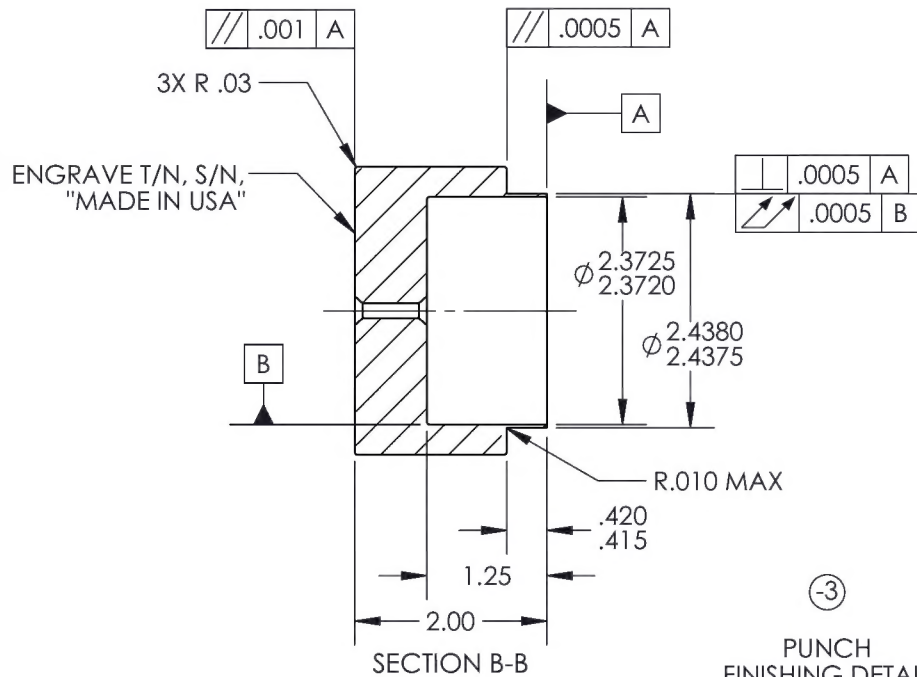
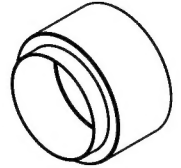
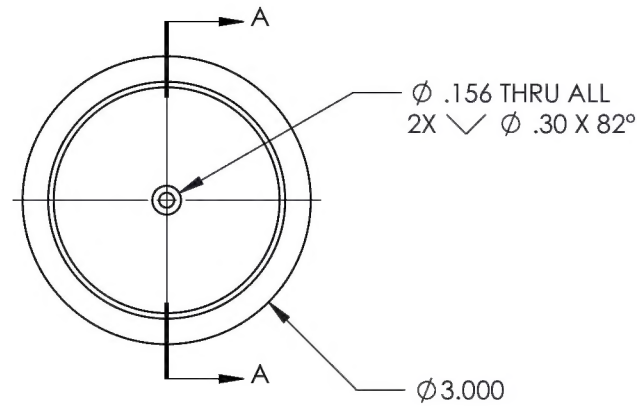
<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL T/R PITCH CONTROL</b>	
DWG NO. <b>RB0006-809-00088-2</b>	REV <b>6</b>
MAT'L <b>STEEL</b>	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
FINISH <b>BLACK OXIDE</b>	.XXX ± .005 FRACTIONS ± 1/8
SPEC <b>QMSI-6.2.2, B.O. REV D</b>	.XX ± .01 ANGLES ± 5°
DRAWN BY: <b>COLE</b>	.X ± .1 SURFACES = 125
CHECKED: <b>DUERFELDT</b>	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
OPPS APPR: <b>ANDERSON</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: <b>LINDSAY</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: <b>GILBERT</b>	USED ON MODEL <b>MD 500</b>
SCALE <b>1:1</b>	DATE <b>12/10/2004</b>
SHEET 3 OF 7	

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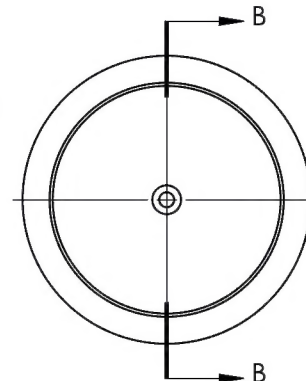
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		ADDED -3 ROUGHING DETAIL.	7/7/2006		
6	17-0047	-3 ADDED FINISH SPEC QMSI-6.2.2, B.O. REV D.	2/28/2017	RJC	JAG



(-3)  
PUNCH  
ROUGHING DETAIL



(-3)  
PUNCH  
FINISHING DETAIL

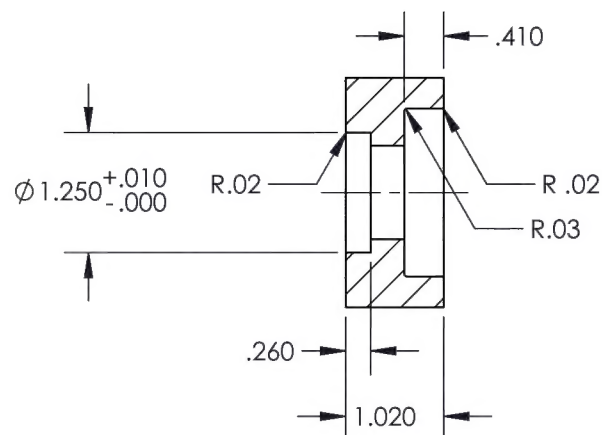


NOTE:  
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

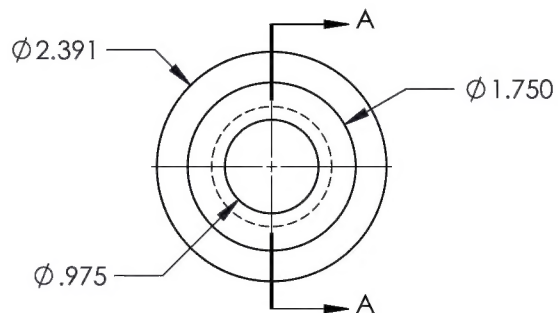
<b>DART AEROSPACE</b>	
TITLE STAKING TOOL T/R PITCH CONTROL	
DWG NO. RB0006-809-00088-3	REV 6
MAT'L O-1	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT RC 55-60	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± .5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DUERFELDT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	MD 500
SCALE 1:2	DATE 12/10/2004
SHEET 4 OF 7	

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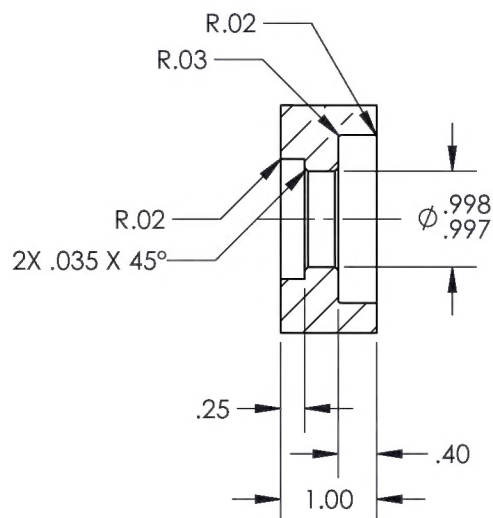
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-4 ID REDUCED TO Ø.995.	6/10/2004		
2		ADDED -4 ROUGHING DETAIL	7/7/2006		
3		-4 ADDED CHAMFER 45° AND LIMITS, CH'D DIM .996 TO .998 & P.F. -.7.	6/8/2015	RJC	
6	17-0047	-4 CH'D FINISH WAS BLACK OXIDE IS SEE -1 & -2.	2/28/2017	RJC	JAG



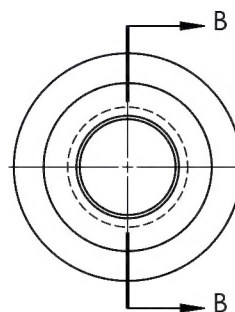
SECTION A-A



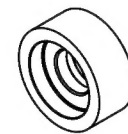
(-4)  
PILOT  
ROUGHING DETAIL



SECTION B-B



(-4)  
PILOT  
FINISHING DETAIL



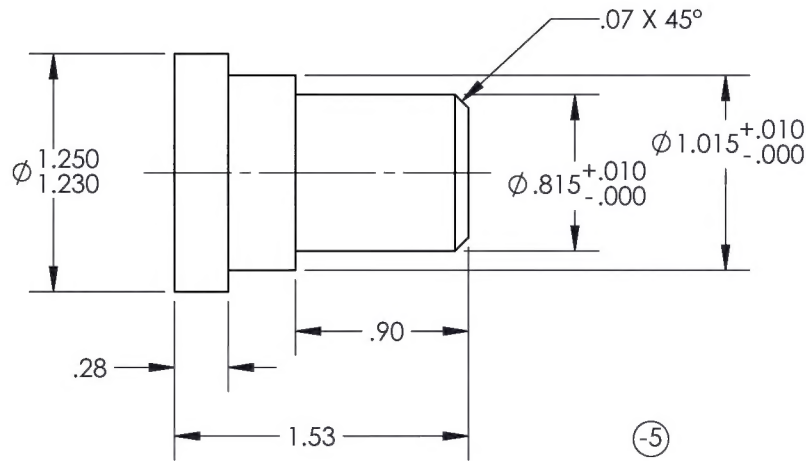
NOTE:  
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

<b>DART</b> AEROSPACE	
TITLE <b>STAKING TOOL T/R PITCH CONTROL</b>	
DWG NO. <b>RB0006-809-00088-4</b>	REV <b>6</b>
MAT'L <b>O-1</b>	UNLESS OTHERWISE SPECIFIED
HEAT TREAT <b>RC 55-60</b>	DIMENSIONS ARE IN INCHES
FINISH <b>SEE -1 &amp; -2</b>	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: <b>COLE</b>	1. BREAK ALL SHARP EDGES
CHECKED: <b>DUERFELDT</b>	.015 x 45° OR .015R
OPPS APPR: <b>ANDERSON</b>	2. DIMENSIONAL LIMITS APPLY
QA APPR: <b>LINDSAY</b>	AFTER PLATING
APPROVED: <b>GILBERT</b>	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	<b>MD 500</b>
SCALE <b>1:2</b>	DATE <b>12/10/2004</b>
	SHEET 5 OF 7

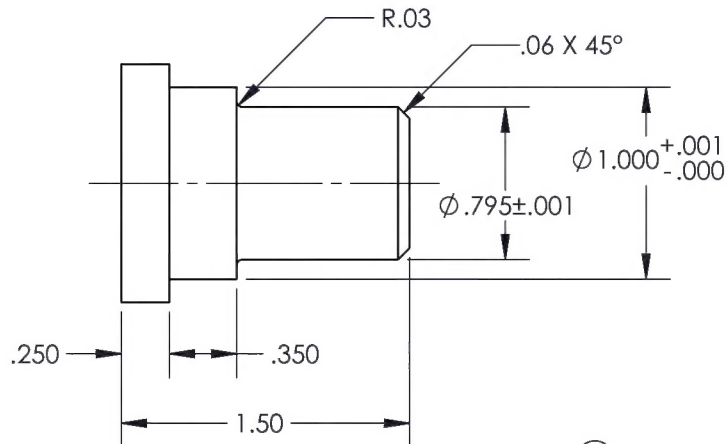
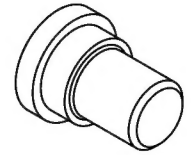


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		-5 STEP OD REDUCED TO Ø.995.	6/10/2004		
4		CH'D -5 FINISH DETAIL FROM Ø.995 +.001 -.000 TO Ø1.000 +.001 -.000 PER G.E.	10/24/2011	RJC	RW
6	17-0047	-5 C'D DIM WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM 1.50. CH'D FINISH WAS BLACK OXIDE IS SEE -1.	2/28/2017	RJC	JAG



(-5)  
GUIDE  
ROUGHING DETAIL



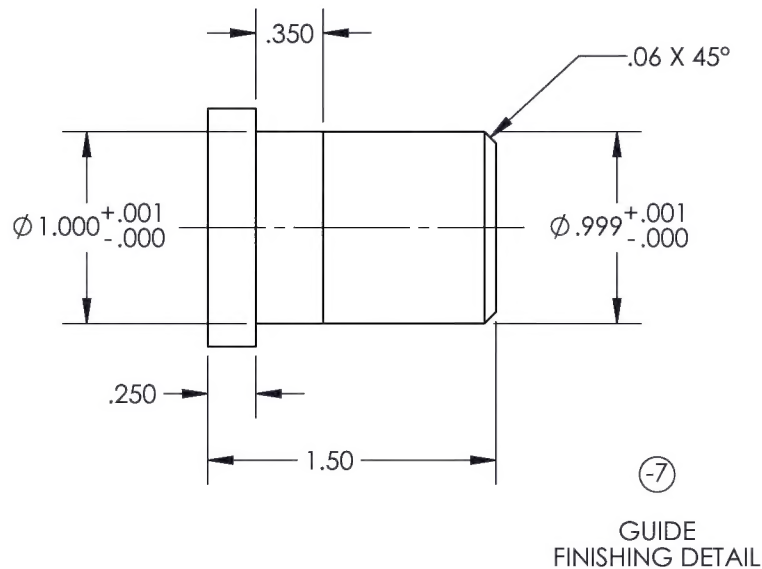
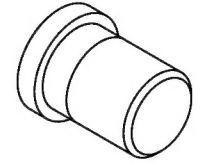
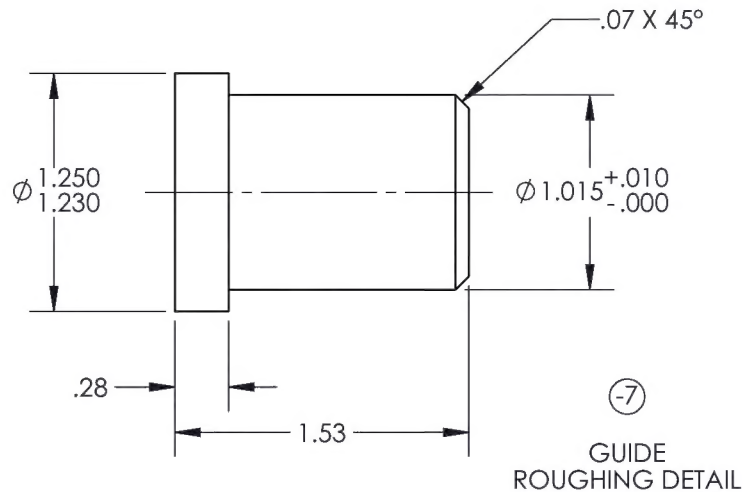
(-5)  
GUIDE  
FINISHING DETAIL

NOTE:  
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

<b>DART</b> AEROSPACE	
TITLE STAKING TOOL T/R PITCH CONTROL	
DWG NO. RB0006-809-00088-5	REV 6
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	MD 500
SCALE 1:1	DATE 12/10/2004
	SHEET 6 OF 7

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4		CH'D -7 FINISH DETAIL FROM $\varnothing.998 +.001 -.000$ TO $\varnothing.999 +.001 -.000$ & ADDED MISSING $\varnothing 1.000 +.001 -.000$ P.F. -4 PER G.E.	10/24/2011	RJC	RW
6	17-0047	-7 CH'D DIM'S WAS .25 IS .28, WAS 1.50 IS 1.53, ADDED DIM'S .250, 1.50. CH'D FINISH WAS BLACK OXIDE IS SEE -2.	2/28/2017	RJC	JAG



NOTE:  
MUST MEET DIMENSIONAL LIMITS AFTER HEAT TREAT.

<b>DART</b> AEROSPACE	
TITLE <b>STAKING TOOL T/R PITCH CONTROL</b>	
DWG NO. <b>RB0006-809-00088-7</b>	REV <b>6</b>
MAT'L O-1	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 55-60	DIMENSIONS ARE IN INCHES
FINISH SEE -2	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DUERFELDT	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	MD 500
SCALE 1:1	DATE 12/10/2004
	SHEET 7 OF 7